

Claims

1. Method for the production of a precise prefabricated concrete part, especially in form of a sleeper or plate (1) for a fixed track for rail-guided vehicles, characterized in that the prefabricated concrete part is ground to the predetermined dimension by means of a grooved roller (21) at the functionally relevant points.
2. Method as in claim 1, characterized in that the grooved roller (21) is used for roughing and planing.
3. Method as in one or several of the preceding claims, characterized in that the grooved roller (21) is adjusted between roughing and planing.
4. Method as in one or several of the preceding claims, characterized in that the prefabricated concrete part is hardened by storing it for several days after pouring and before grinding.
5. Method as in one or several of the preceding claims, characterized in that the functionally relevant points are supporting points (3) or installation surfaces for the installation of the rail (5) or contact points of several prefabricated concrete parts that are ground.

6. Method as in one or several of the preceding claims, characterized in that the blank is placed in a defined position for grinding, in particular corresponding to its subsequent installation position.
7. Method as in one or several of the preceding claims, characterized in that the blank is placed in position free of tension for grinding.
8. Method as in one or several of the preceding claims, characterized in that the current wear of the tool is taken into consideration in grinding the functionally relevant points.
9. Method as in one or several of the preceding claims, characterized in that the actual dimensions and target dimensions of the points to be ground are controlled.
10. Method as in one or several of the preceding claims, characterized in that the lowest supporting point (3) of the plate (1) is used as a basis for the grinding of the additional supporting points (3) of the plate (1).
11. Method as in one or several of the preceding claims, characterized in that the blank is produced in rotational production and is made in particular of fiber concrete.

12. Method as in one or several of the preceding claims, characterized in that the blank is ground on a milling machine, in particular on a grinding machine (15).
13. Device for the production of a precise prefabricated concrete part, especially in form of a sleeper or a plate (1) for a fixed track for rail-guided vehicles, characterized in that the device is a grinding machine (15) with a grooved roller (21) to grind the prefabricated concrete part at functionally relevant points to a predetermined dimension and whereby the grooved roller (21) is made of a wear-resistant material, in particular silicon carbide.
14. Device as in the preceding claim, characterized in that the wear-resistant material is located on a steel shaft.
15. Device as in one or several of the preceding claims, characterized in that an adjusting device (25) can be presented to the wear-resistant material.
16. Device as in one or several of the preceding claims, characterized in that the adjusting device (25) is provided with a diamond coating.
17. Device as in one or several of the preceding claims, characterized in that the profile roller (21) has a diameter between 700 and 400 mm.

18. Device as in one or several of the preceding claims, characterized in that the device is assigned a measuring system to measure the tool and/or the functionally relevant points of the prefabricated concrete part to be ground.
19. Device as in one or several of the preceding claims, characterized in that the grooved roller (21) can be used to rough and to plane the prefabricated concrete part.
20. Device as in one or several of the preceding claims, characterized in that the device has several grooved rollers (21) so that several functionally relevant points can be ground at the same time.